

Work Order ID 164773

Friday, July 28, 2017 2:38:51 PM

Shy 4 Aug
Push *164773*

Page 1

Item ID: D4965-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Spacer

Start Date: 7/28/2017

Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/2/2017

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4965	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.63							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.05							
Quality Control									

(4) *07/27/31*

(4) *07/27/31*

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Item ID: D4965-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 7/28/2017 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 8/2/2017 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.10				4			DAS 38 9-89 JUL 31 2017
130 *130* Brake NC Brake NC	Bend as per dwg Memo FORM FLANGE AS PER DWG USING DT8174	0.13 0.54				4			DAS 19 9-89 17/02/31 DAS 36 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.10				4			DAS 38 9-89 AUG 01 2017

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Setup Start *NS1*

Stop *NS2*

Start Date: 7/28/2017 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 8/2/2017 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00

160

Memo

0.55

HandFinish

Hand Finishing

170

QC7-Inspect Chemical Conversion Coat

0.00

170

Memo

0.05

QC

Quality Control

180

Identify as per dwg & Stock Location:

0.00

180

Memo

0.05

Packaging

Packaging

LOCATION : GA

DAS
30
9-89

**DAS
30
9-89**

AUG 01 2017

AUG 01 2017

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/28/2017 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 8/2/2017 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.50

Quality Control

DAS
21
9-89

AUG 01 2017

Picklist Print

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Work Order ID: 164773

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Parent Item: D4965-3

D4965-3

Parent Item Name: Step Spacer

Start Date: 7/28/2017

Required Date: 8/2/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.11.05 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	47.0000	0.27	1.421053			
M2024T3S 040										**		07/07/31	
2024-T3 .040 sheet													

Location

Loc Qty

Loc Code

MAT022

47

m137884

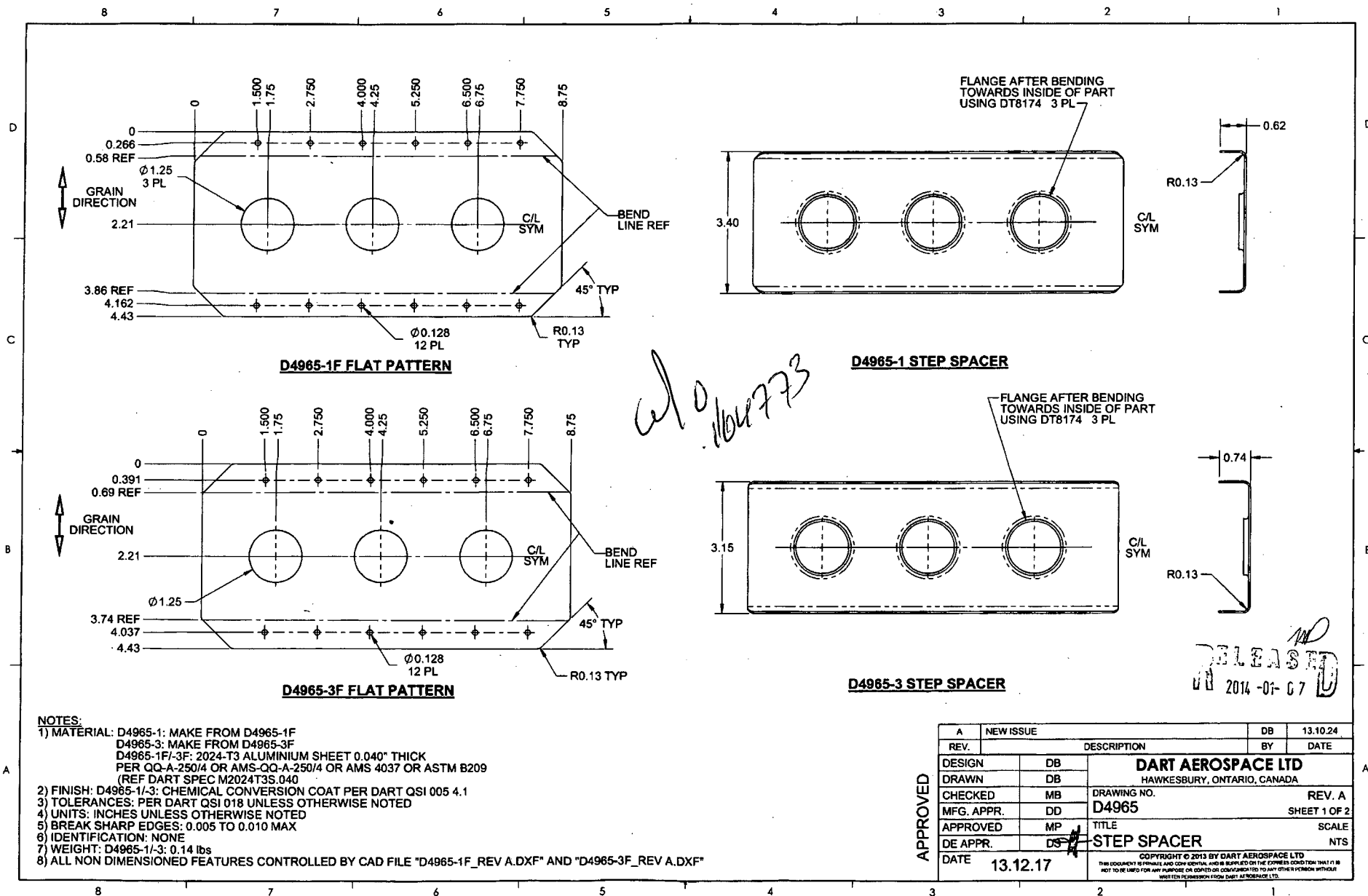
47

137237

137041

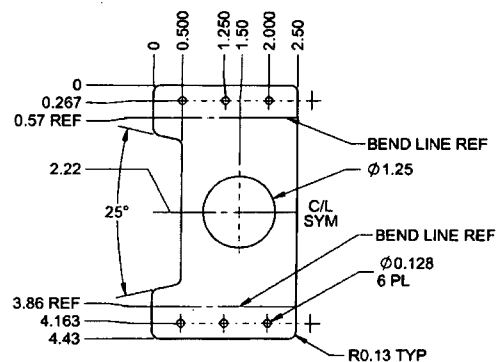
.6

.3

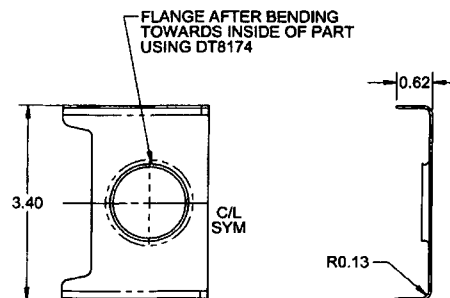


8 7 6 5 4 3 2 1

GRAIN
DIRECTION

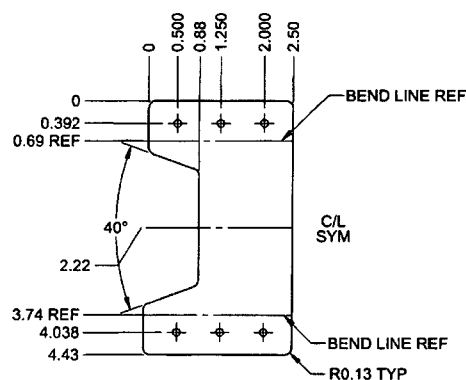


D4965-5F FLAT PATTERN

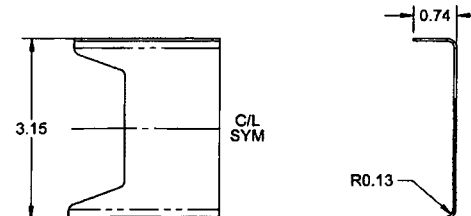


D4965-5 STEP SPACER

GRAIN
DIRECTION



D4965-7F FLAT PATTERN



D4965-7 STEP SPACER

NOTES:

- 1) MATERIAL: D4965-5: MAKE FROM D4965-5F
D4965-7: MAKE FROM D4965-7F
D4965-5F/7F: 2024-T3 ALUMINIUM SHEET 0.040" THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: D4965-5/-7: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4965-5/-7: 0.01 lbs
- 8) ALL NON DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4965-5F_REV A.DXF" AND "D4965-7F_REV A.DXF"

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. A
MFG. APPR.	DD	D4965	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STEP SPACER	NTS
DATE	13.12.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2014-01-07

8 7 6 5 4 3 2 1